

Date: Monday, 9/18/2006 2:26:09 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WASHER	
Job Number	: 28632		Part Number	: D31375	
Estimate Number	: 10374		Drawing Number	: D3137 REV E	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 9/18/2006 S.O. No. : N/A		Drawing Revision	: E	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 9/25/2006	
Previous Run	: 27246		Qty:	120	
Written By	: <u>JK</u> 06 09.18		Um:	100	
Checked & Approved By			Each		
Comment	: Est A 04.11.04 New issue KJ/JLM				

## Additional Product

Job Number:		
Seq. #: Machine Or Operation: Description :		
1.0	M6061T6R0750	6061-T6 Round Bar .750"
		
Comment:	Qty.: 0.0218 f(s)/Unit Total : 2.1840 f(s) 6061-T6 Round Bar <del>.750</del> <sup>0.750</sup> Material: 6061-T6 Aluminum Bar <del>.7500"</del> (QQ-A-200/8 or QQ-A-225/8) (M6061T6R1.500) Batch: M19430	2.18 10.38 06/09/19
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		
Comment:	HARDINGE CNC LATHE SMALL 1-Machine as per Folio FA471 and Dwg D3137 2-Identify as D3137-5 3-Deburr	 06/09/19 120
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE	06/09/19 120
4.0	QC8	SECOND CHECK
		
Comment:	SECOND CHECK	06/09/19 120
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
Comment:	HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	06:09:20 120

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/09/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/18/2006 2:26:10 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WASHER

Job Number: 28632

Part Number: D31375

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
7.0	QC5	INSPECT WORK TO CURRENT STEP 
8.0	PACKAGING 1	PACKAGING RESOURCE #1 
9.0	QC21	FINAL INSPECTION/W/O RELEASE 

Job Completion



U 06-09-20  
120

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28632
Description: Washer	Part Number:	D3137-5
Inspection Dwg: D3137	Rev: E	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

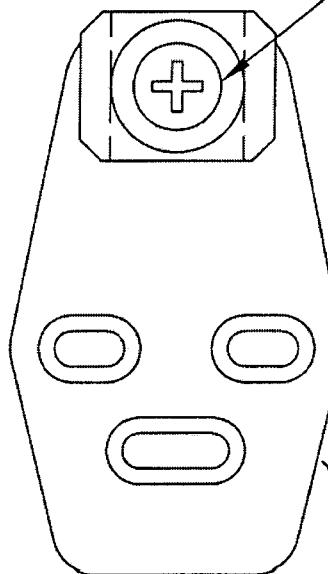
Measured by:		Audited by:		Prototype Approval:	N/A
Date:	06/09/19	Date:	06.09.19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.12	New Issue	KJ/JLM	
B	06.03.15	Ø0.650 dimension added; Ø0.660 dimension removed	KJ/JLM	

**DART**

DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3137	REV. E SHEET 1 OF 5
DATE 05.11.23		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	02.04.17	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP.	
C	03.08.15	ADD -043	
D	04.11.03	RE-DESIGN D3137-5; CHANGE DIMS	
E	05.11.23	ADD -045	

RELEASED

05.12.09 *#*

MS24694-S101 SCREW  
D3137-5 WASHER  
D3137-3 GUIDE  
INSTALL ON SAME SIDE AS C'SINKS  
(OPPOSITE SIDE FROM RIDGES)

D3137-1 BRACKET (-041 SHOWN)  
OR  
D3137-7 BRACKET (-043 SIMILAR)  
OR  
D3137-9 BRACKET (-045 SIMILAR)

D3137-041 BRACKET ASSEMBLY (SHOWN)  
D3137-043 BRACKET ASSEMBLY (SIMILAR)  
D3137-045 BRACKET ASSEMBLY (SIMILAR)

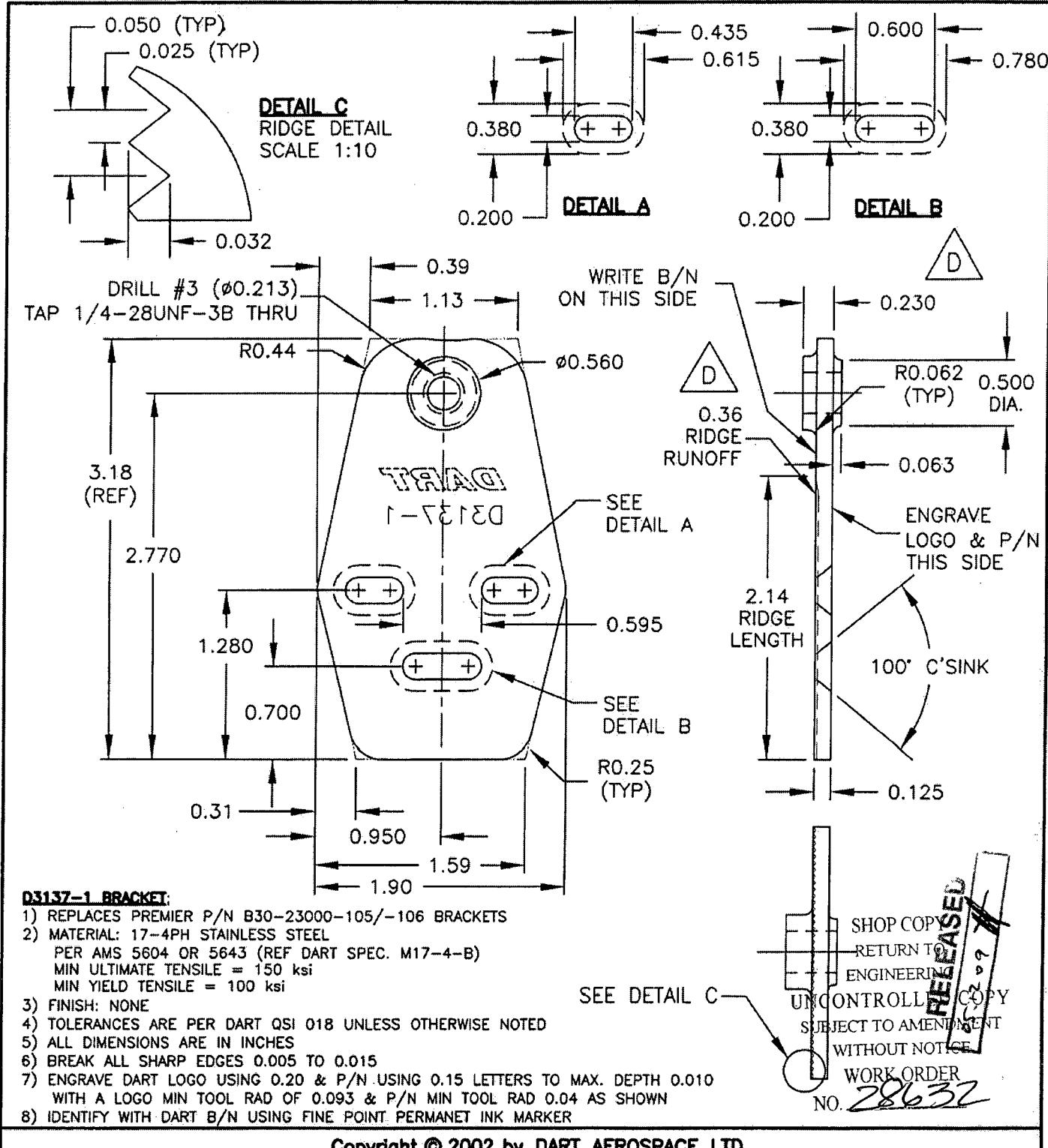
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CHECKED <b>#</b>	APPROVED <b>#</b>	DRAWING NO. <b>D3137</b>	REV. E SHEET 2 OF 5
DATE <b>05.11.23</b>		TITLE <b>BRACKET ASSEMBLY</b>	SCALE <b>1:1</b>

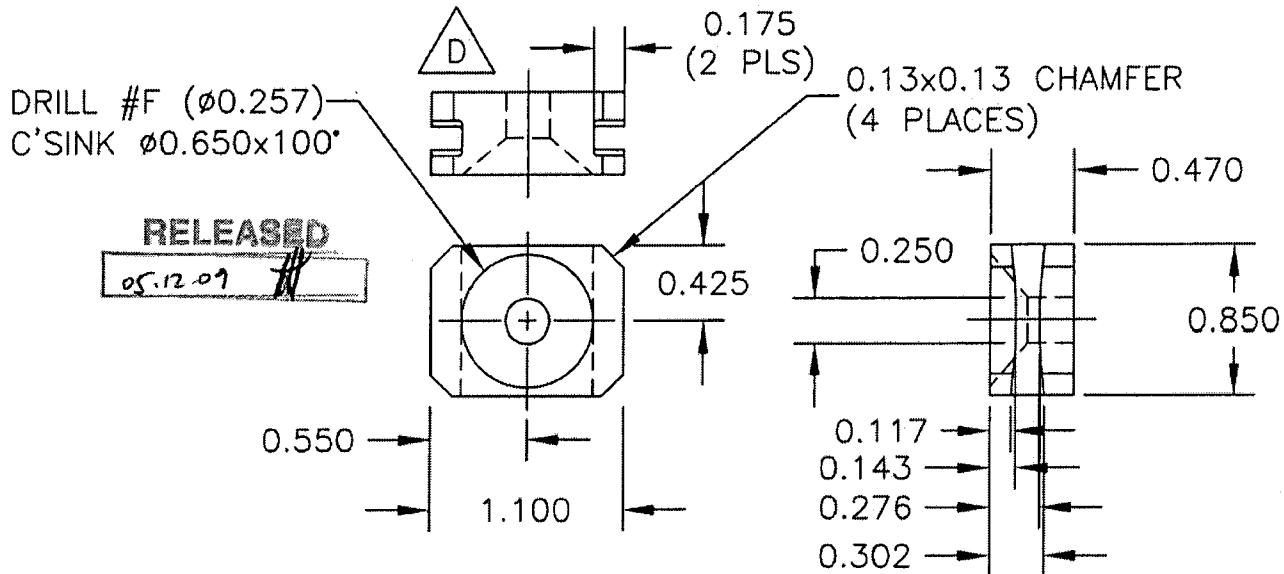


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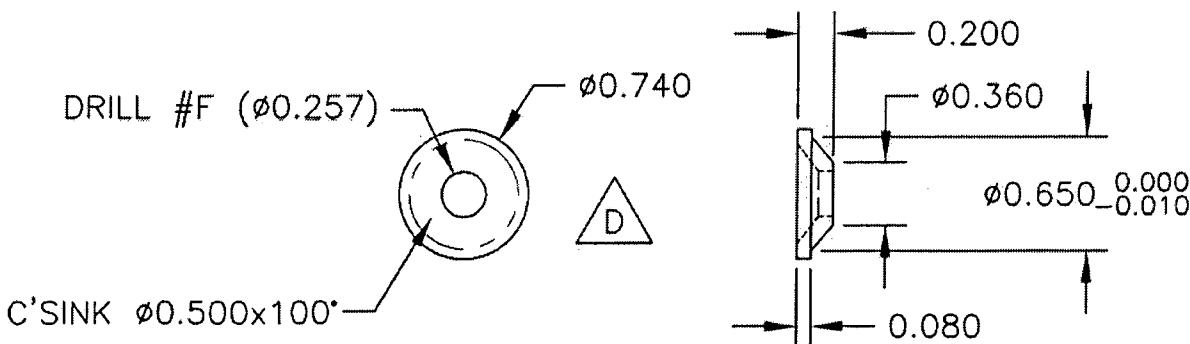
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DATE 05.11.23		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3137-3 GUIDE**

- 1) REPLACES PREMIER P/N B30-23000-207
- 2) MATERIAL: DELRIN BAR (REF DART SPEC. M-DELRIN-B)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL EDGES 0.005 TO 0.015

**D3137-5 WASHER**

- 1) REPLACES PREMIER P/N B30-23000-209
- 2) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF DART SPEC. M6061T6R)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL EDGES 0.005 TO 0.015

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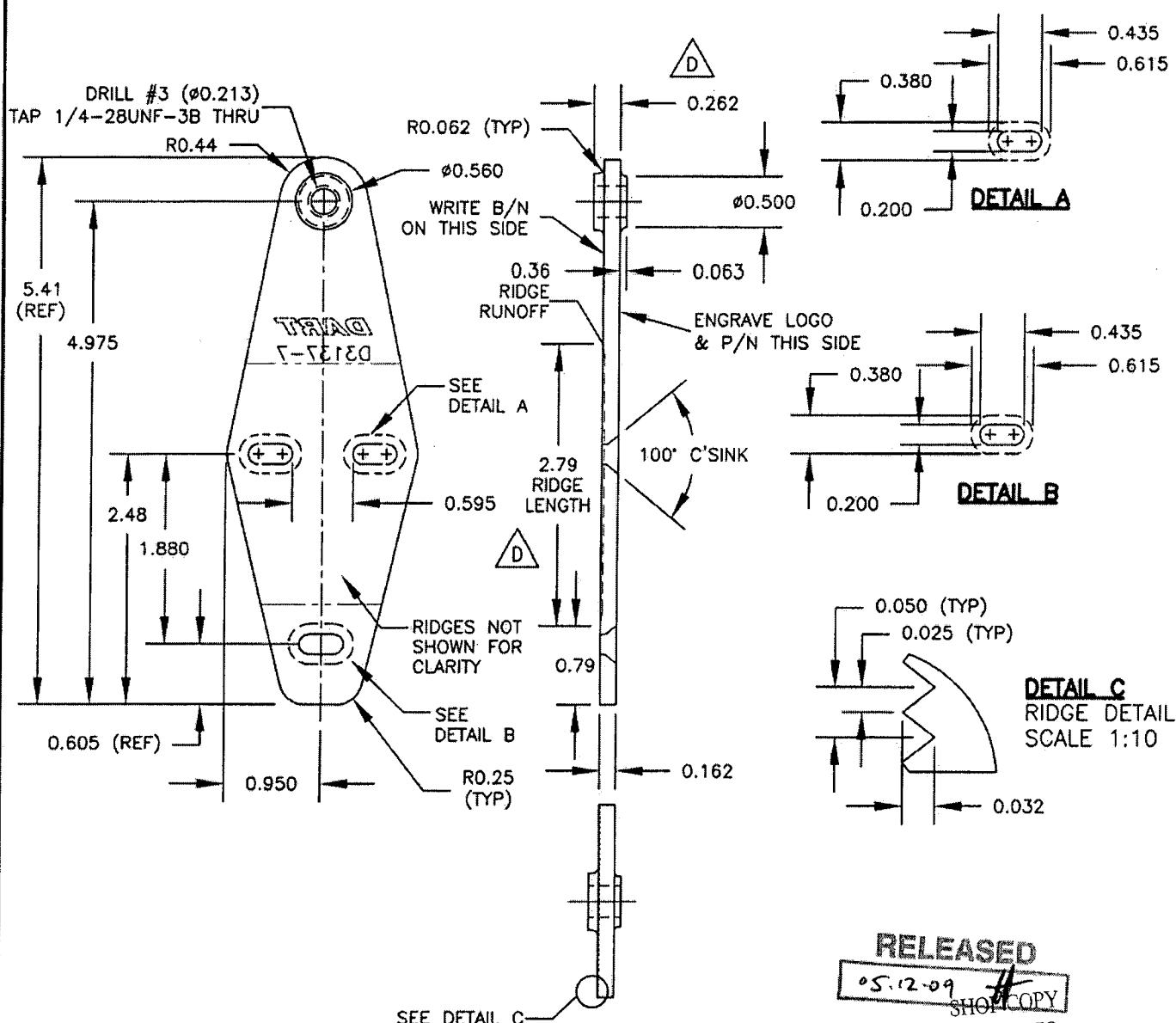
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CHECKED 	APPROVED 	DRAWING NO. D3137	REV. E SHEET 4 OF 5	
DATE 05.11.23	TITLE BRACKET ASSEMBLY		SCALE 2:3	



**D3137-7 BRACKET**

- 1) MATERIAL: 17-4PH STAINLESS STEEL PER AMS 5604 OR 5643 (REF DART SPEC. M17-1)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010  
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 7) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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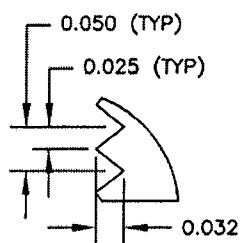
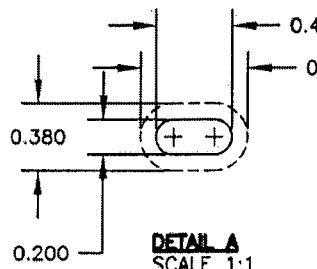
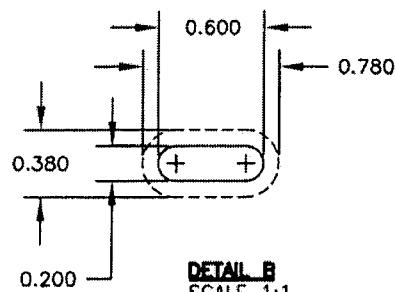
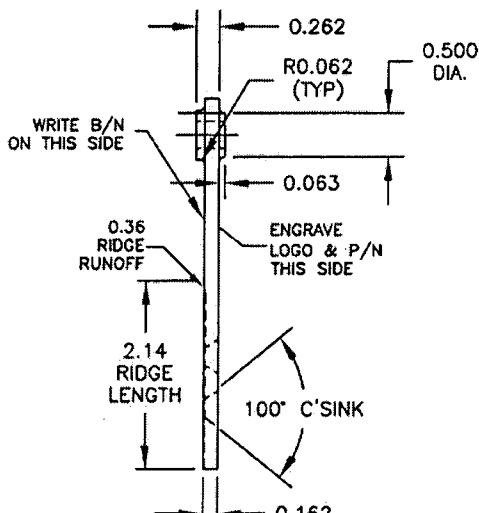
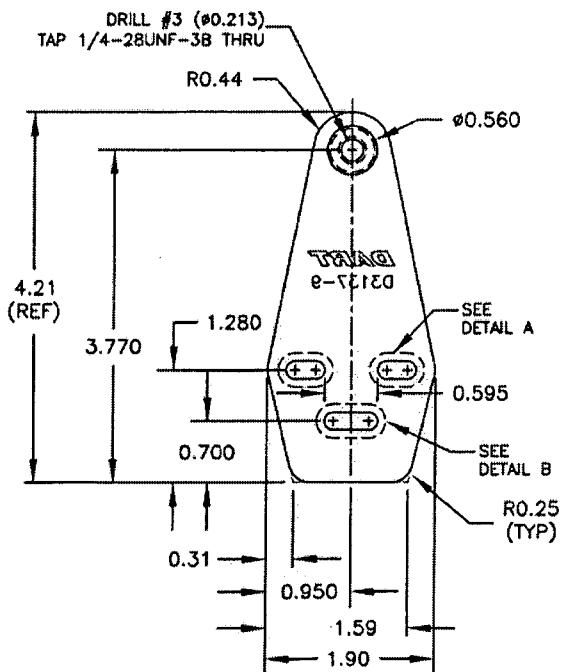
11. *What is the name of the author of the book you are reading?*

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DATE 05.11.23		TITLE BRACKET ASSEMBLY	SCALE 1:2

**DETAIL C**  
RIDGE DETAIL  
SCALE 1:20**DETAIL A**  
SCALE 1:1**DETAIL B**  
SCALE 1:1**D3137-9 BRACKET:**

- 1) REPLACES PREMIER P/N B30-23000-105/-106 BRACKETS
- 2) MATERIAL: 17-4PH STAINLESS STEEL  
PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010  
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 8) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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